

Work Order ID 80901

Monday, March 05, 2012 9:57:45 AM

80901

today

Page 1

Item ID: D3874-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector

Start Date: 3/5/2012 Start Qty: 1.00

4

Cust Item ID:

Required Date: 3/8/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 12-03-05 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3874

Rev A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

DL
12/03/07

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 276° F

Time IN: 7:00 pm 12/02/06

Time OUT: 6:00 am 12/02/07

x2

DL
12/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474

Dwg Rev: AFolio Rev: B

x2

Dh.
12/03/07

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

Visually inspect part for proper formation and texture

x2

Dh.
12/03/07

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

x2

Dh.
12/03/08

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2.

DH
12/03/08

150

150

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Complete FAI document

x2

DH
12/03/08

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/12/03/08

(12)

Dart Aerospace Ltd

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Reference:

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/3/85 1/2

J

MLJ 12/03/08

12-03-8

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8 7 6 5 4 3 2 1

D

C

B

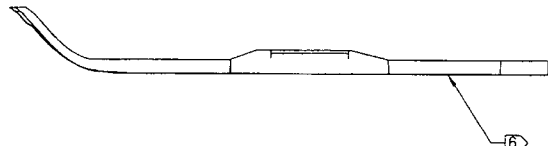
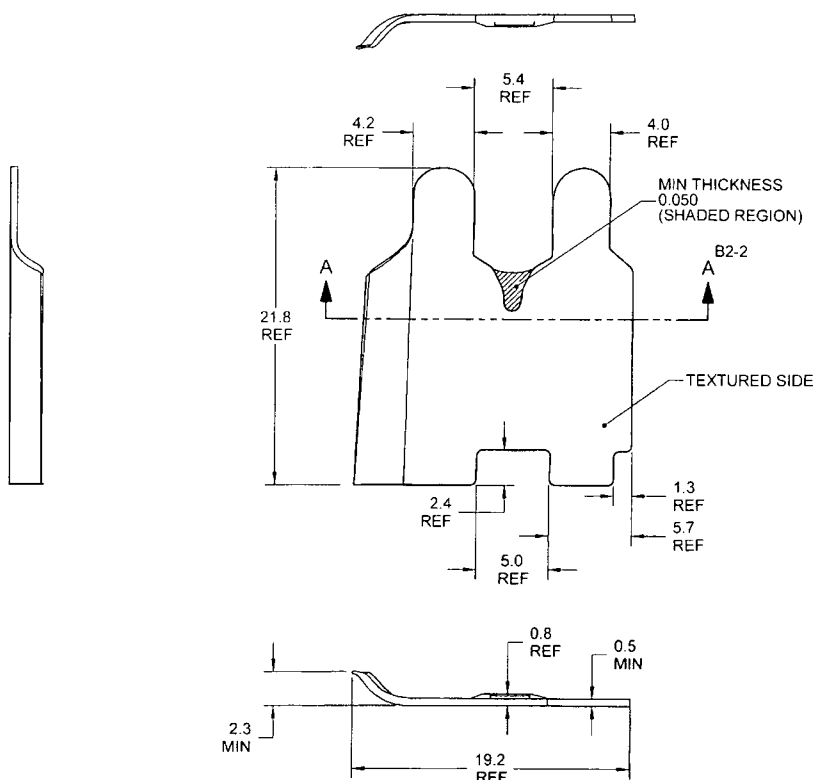
A

D

C

B

A



SECTION A-A
SCALE 2X

C5-2

D3874-1 FLOOR PROTECTOR

- NOTES:**
- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
 - 7) WEIGHT: 1.5 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

#80901

RELEASED
9/25/05

DESIGN	PA	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV.
MFG. APPR.	PA	D3874	
APPROVED	PA	TITLE	SHEET 2 OF
DE APPR.	PA	FLOOR PROTECTOR	SCALE
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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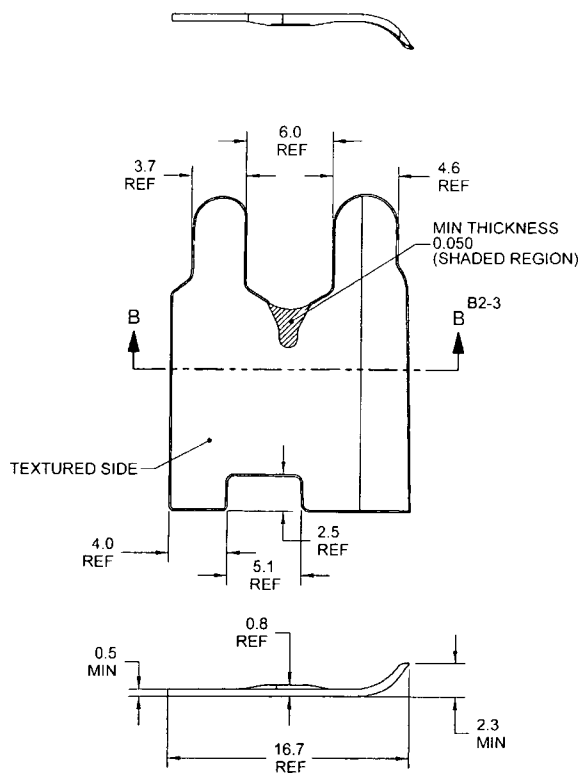
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D

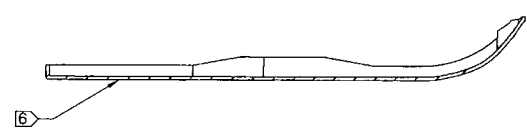
C

B

A



D3874-2 FLOOR PROTECTOR



SECTION B-B
SCALE 2X

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

80901

RELEASED
8/15/03

DESIGN	Ref	DART AEROSPACE LTD	
DRAWN	Ref	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Ref	DRAWING NO.	REV. A
MFG. APPR.	Ref	D3874	SHEET 3 OF 3
APPROVED	Ref	TITLE	SCALE
DE APPR.	Ref	FLOOR PROTECTOR	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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DART AEROSPACE LTD		Work Order:	80901
Description: Floor Protector		Part Number:	D3874-1
Inspection Dwg: D3874	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL Date: 17/03/07

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.100"	✓		CAL TH-DT	
0.065	Min	0.099"	✓		CAL TH-DT	
0.5	Min	0.52	✓		Veru DL-02	

Measured by: DL Date: 17/03/08

Audited by: JB Date: 17/03/08

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>JA</u>

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